

Friday, June 09, 2017 10:39:24 AM

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[illegible]

Work Order ID 162716

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162716

Page 2

Item ID: D4820-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: FPC Clip Assembly
Start Date: 6/9/2017 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 7/18/2017 Req'd Qty: 40.00 ***40*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>S129.</u>	0.00							
130									
Packaging	Memo	0.40				40x		DAS 26 9-89	JUN 27 2017
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	4.00							17/7/3 
Quality Control									

DAS
21
9-89 JUN 27 2017

Picklist Print

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Work Order ID: 162716

162716

Parent Item: D4820-041

D4820-041

Parent Item Name: FPC Clip Assembly

Start Date: 6/9/2017

Required Date: 7/18/2017

Start Qty: 40.00

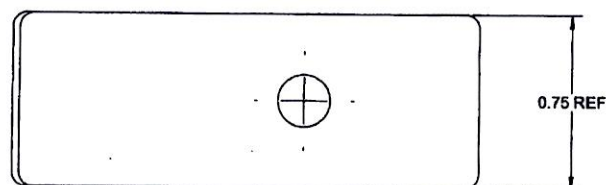
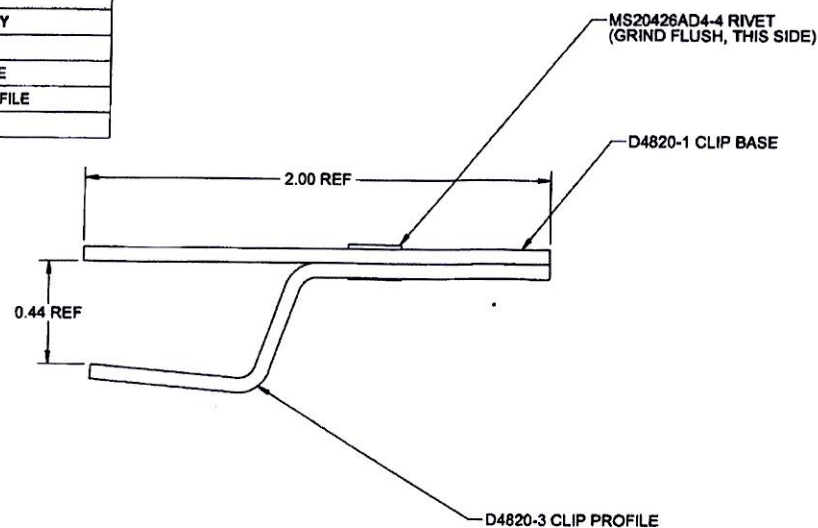
Required Qty: 40.00

Comments: IPP REV:A NEW ISSUE 13-04-15 JLM VERIFIED BY:DD

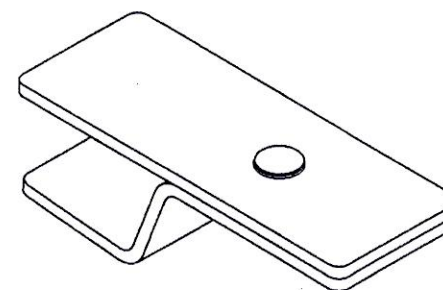
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4820-1 *D4820-1* Fpc Clip Base		Manufactured	No			100	Each	2.0000	1	40			
				<u>Location</u>				<u>Loc Qty</u>					
				GA				2					
					161372			2		2			
D4820-3 *D4820-3* Fpc Clip Profile		Manufactured	No			100	Each	5.0000	1	40			
				<u>Location</u>				<u>Loc Qty</u>					
				GA				5					
					161373			5		5			
MS20426AD4-4 *MS20426AD4-4* Rivet		Purchased	No			100	Each	2,600.000	1	40			
				<u>Location</u>				<u>Loc Qty</u>					
				GA				1121					
					125445			1121		40			
				ST312				1479					
					m132536			1479					

17/06/19 08:38
162898 (6x)
162718 (32x)
17/06/19 08:38
B162918 (3x)
162717 (32x)
17/06/19 08:38

ITEM	QTY	P/N	DESCRIPTION
	X	D4820-041	CLIP ASSY
1	1	D4820-1	CLIP BASE
2	1	D4820-3	CLIP PROFILE
3	1	MS20426AD4-4	RIVET



D4820-041 CLIP ASSY

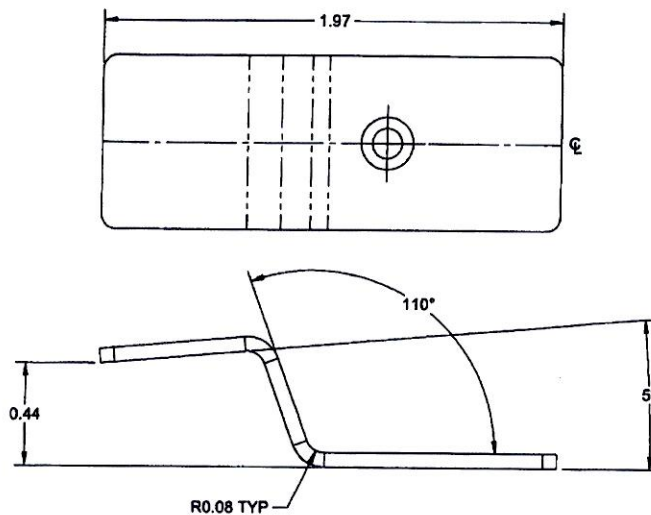


RELEASED
2013-04-18
MP

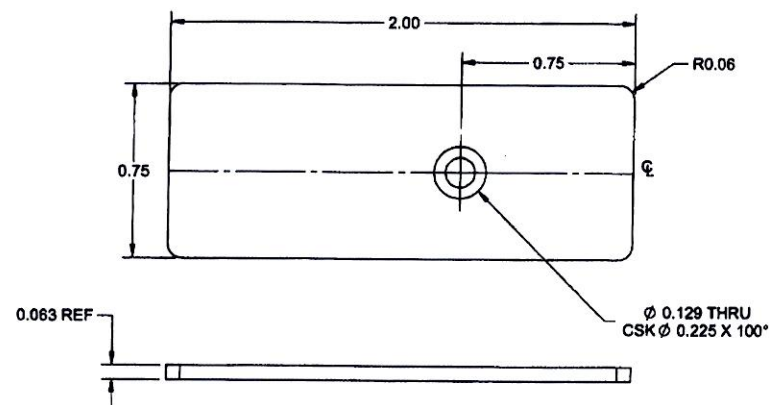
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4820-041" USING FINE POINT PERMANENT MARKER, QSI 044, METHOD 6.1
- 7) WEIGHT: 0.06 lbs

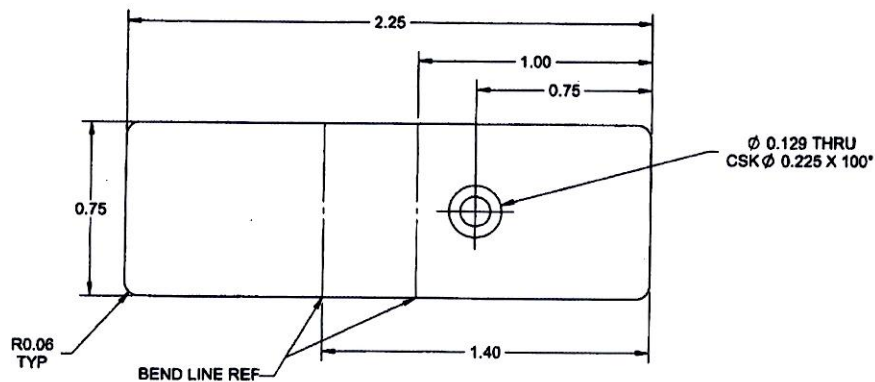
A	NEW ISSUE	DB	13.04.10
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	AP	D4820	SHEET 1 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	CLIP ASSY	NTS
DATE	13.04.10	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4820-3 CLIP PROFILE
(MAKE FROM D4820-3F)



D4820-1 CLIP BASE



D4820-3F FLAT PATTERN

RELEASED
2013-04-18

NOTES:

- 1) MATERIAL: AISI 304/316 SS, 0.063" THICK AS PER DART SPEC M304S16GA1P OR MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4820-1: 0.03 lbs, D4820-3: 0.03lbs

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.		D4820	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CLIP ASSY	NTS
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